

Date: Monday, 27/04/2009 12:51:00 PM  
 User: Julie Dawson

## Process Sheet

|  |   |
|--|---|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services  | <b>Drawing Name</b> : WEARPLATE                             |
| <b>Job Number</b> : 47524                              |   |
| <b>Estimate Number</b> : 12731                         |   |
| <b>P.O. Number</b> :                                   | <b>Part Number</b> : D353535 <b>GY</b>                      |
| <b>This Issue</b> : 27/04/2009 <b>S.O. No.</b> :       | <b>Drawing Number</b> : D3535 REV B                         |
| <b>Prsht Rev.</b> : NC                                 | <b>Project Number</b> : N/A                                 |
| <b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB  | <b>Drawing Revision</b> : B                                 |
| <b>Previous Run</b> : 39233                            | <b>Material</b> :   |
| <b>Written By</b> :                                    | <b>Due Date</b> : 07/05/2009 <b>Qty:</b> 10 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> : <u>JUD 09.04.27</u> |   |
| <b>Comment</b> : Est Rev:A New Issue 07-02-15 JLM      |   |
| Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC     |   |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |           |                    |
|-----|-----------|--------------------|
| 1.0 | M304S20GA | 304/316 .040 Sheet |
|-----|-----------|--------------------|



**Comment:** Qty.: 0.8423 sf(s)/Unit Total : 8.4231 sf(s)  
 304/316 .040 Sheet  
 (M304S20GA)  
 Batch: 111571 **B 9-5-20**

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3535  
 Dwg Rev: B  
 Prog Rev: B **B 9-5-20**  
 2-Deburr if necessary **B 9-5-20**

(13)

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

**B 9-5-20**

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



**Comment:** SECOND CHECK

**S 09/05/20 (13)**

|     |          |          |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



**Comment:** NC BRAKE  
 1-Deburr if necessary  
 2-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.  
 3-Identify as D3535-35.

**SB 09/05/20 (13)**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Monday, 27/04/2009 12:51:00 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 47524

Part Number: D353535

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

809/15/21 (X13)

7.0

POWDER COATING

POWDER COATING



11109091



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

8:45am

OVEN TEMPERATURE:

320°C

FINISH TIME:

9:15am

11

01-05-25

(X13)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

cmd / PL 09/05/25 (X13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-18

cmd

09/05/25 (X13)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/26

Job Completion



MF 09-05-25

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|                              |               |                              |
|------------------------------|---------------|------------------------------|
| <b>DART AEROSPACE LTD</b>    |               | <b>Work Order:</b> 47524     |
| <b>Description:</b> Wearshoe |               | <b>Part Number:</b> D3535-35 |
| <b>Inspection Dwg:</b> D3535 | <b>Rev:</b> B | <b>Page 1 of 1</b>           |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 2.000             | +/-0.010      | 2.000            | X      |        |                      |          |
| 1.885             | +/-0.010      | 1.887            | X      |        |                      |          |
| 6.00              | +/-0.030      | 6.00             | X      |        |                      |          |
| 6.75              | +/-0.030      | 6.75             | X      |        |                      |          |
| Ø0.188            | +0.005/-0.001 | .192             | X      |        |                      |          |
| 23.250            | +/-0.010      | 23.250           | X      |        |                      |          |
| 19.750            | +/-0.010      | 19.750           | X      |        |                      |          |
| 17.750            | +/-0.010      | 17.750           | X      |        |                      |          |
| 14.250            | +/-0.010      | 14.250           | X      |        |                      |          |
| 9.500             | +/-0.010      | 9.500            | X      |        |                      |          |
| 4.750             | +/-0.010      | 4.750            | X      |        |                      |          |
| 0.300             | +/-0.010      | .304             | X      |        |                      |          |
| 0.300             | +/-0.010      | .304             | X      |        |                      |          |
| 0.038             | +/-0.010      | .039             | X      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                       |                       |                            |     |
|-----------------------|-----------------------|----------------------------|-----|
| <b>Measured by:</b> B | <b>Audited by:</b> S  | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b> 9-5-20   | <b>Date:</b> 09/05/20 | <b>Date:</b>               | N/A |

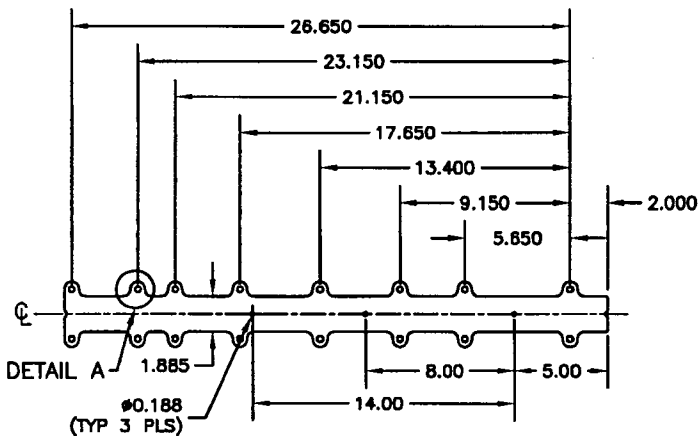
| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 07.05.10 | New Issue | KJ/JLM     | B        |

**DART**

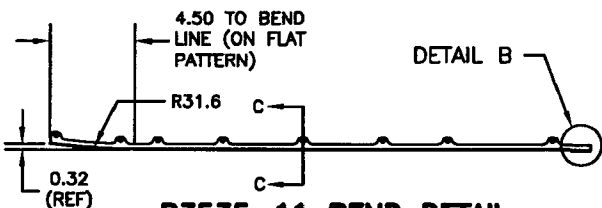
RELEASED

07.04.24

| DESIGN   | DRAWN BY                        | DART AEROSPACE USA, INC. |
|----------|---------------------------------|--------------------------|
| C.B.     | PH                              | PORT HADLOCK, WA         |
| CHECKED  | APPROVED                        | DRAWING NO.              |
| PH       | PH                              | D3535                    |
| DATE     | TITLE                           | REV. B                   |
| 07.04.17 | WEARSHOE                        | SHEET 1 OF 7             |
| A        | NEW ISSUE                       | SCALE                    |
| B        | MOVE TAB OUTBOARD, ADD AMS SPEC | 1:10                     |

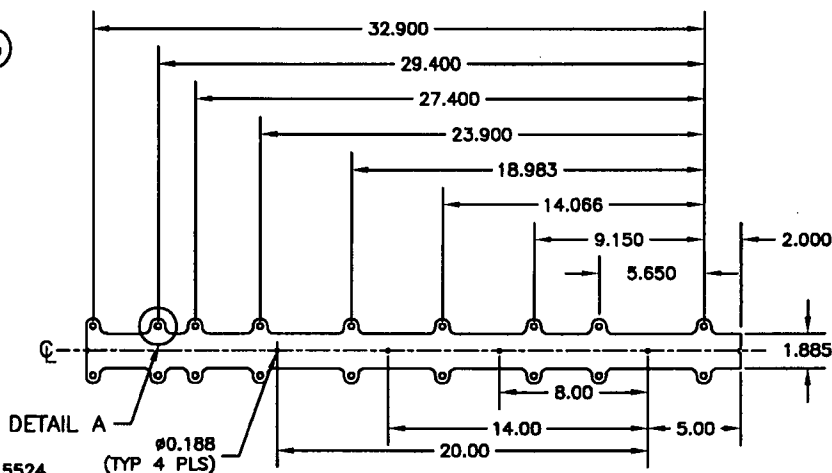


**D3535-11F FLAT PATTERN**

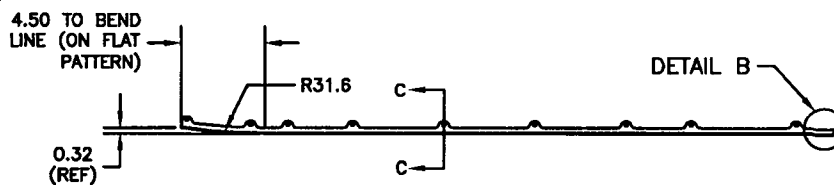


**D3535-11 BEND DETAIL**

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WITHOUT NOTICE  
WORK ORDER  
NO. 17554



**D3535-13F FLAT PATTERN**



**D3535-13 BEND DETAIL**

**NOTES**

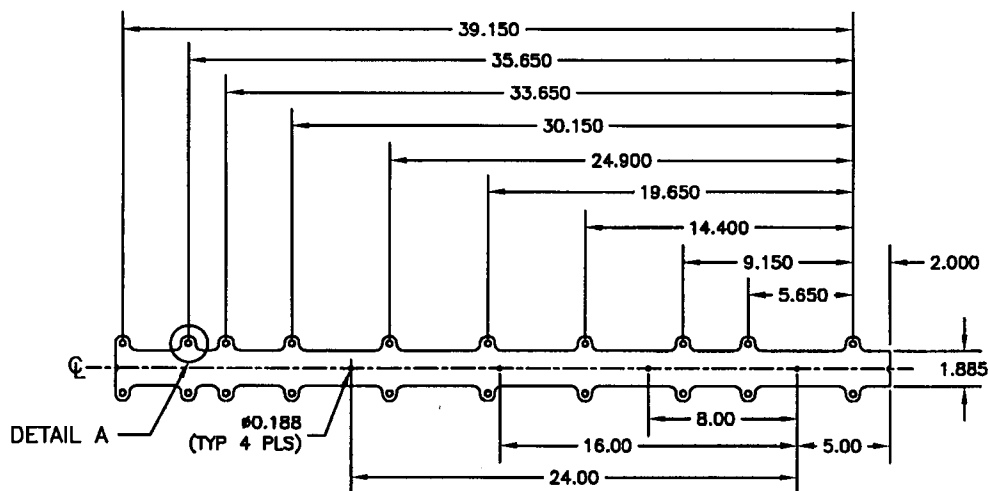
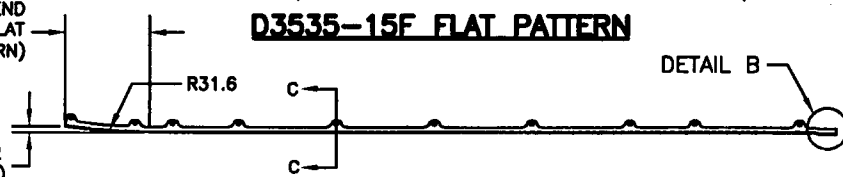
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**DART**

RELEASED

07.04.24

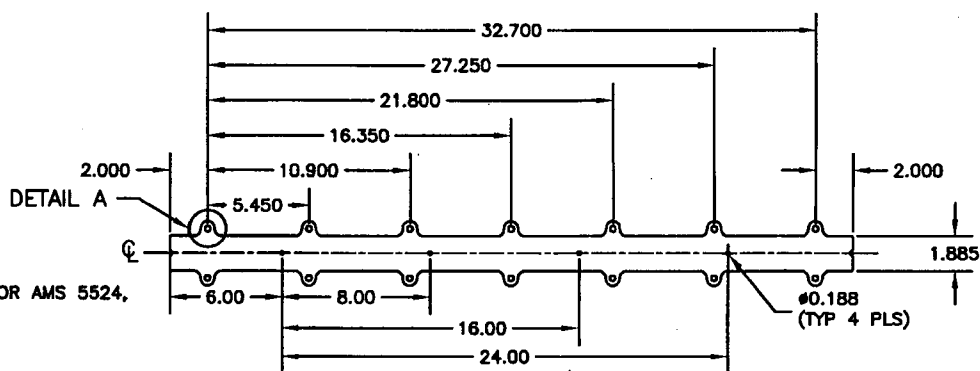
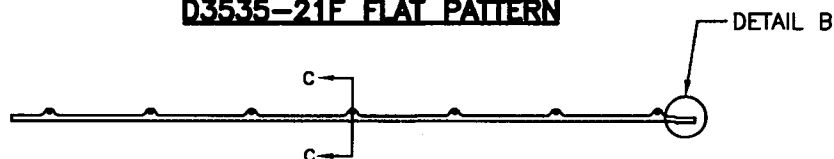
|         |          |             |          |                          |
|---------|----------|-------------|----------|--------------------------|
| DESIGN  | C.B.     | DRAWN BY    | PH       | DART AEROSPACE USA, INC. |
| CHECKED |          | APPROVED    |          | PORT HADLOCK, WA         |
| DATE    | 07.04.17 | DRAWING NO. | D3535    | REV. B                   |
|         |          | TITLE       | WEARSHOE | SHEET 2 OF 7             |
|         |          | SCALE       | 1:10     |                          |

**D3535-15F FLAT PATTERN**4.50 TO BEND  
LINE (ON FLAT  
PATTERN)0.32  
(REF)**D3535-15 BEND DETAIL**

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NO. 41584

**NOTES**

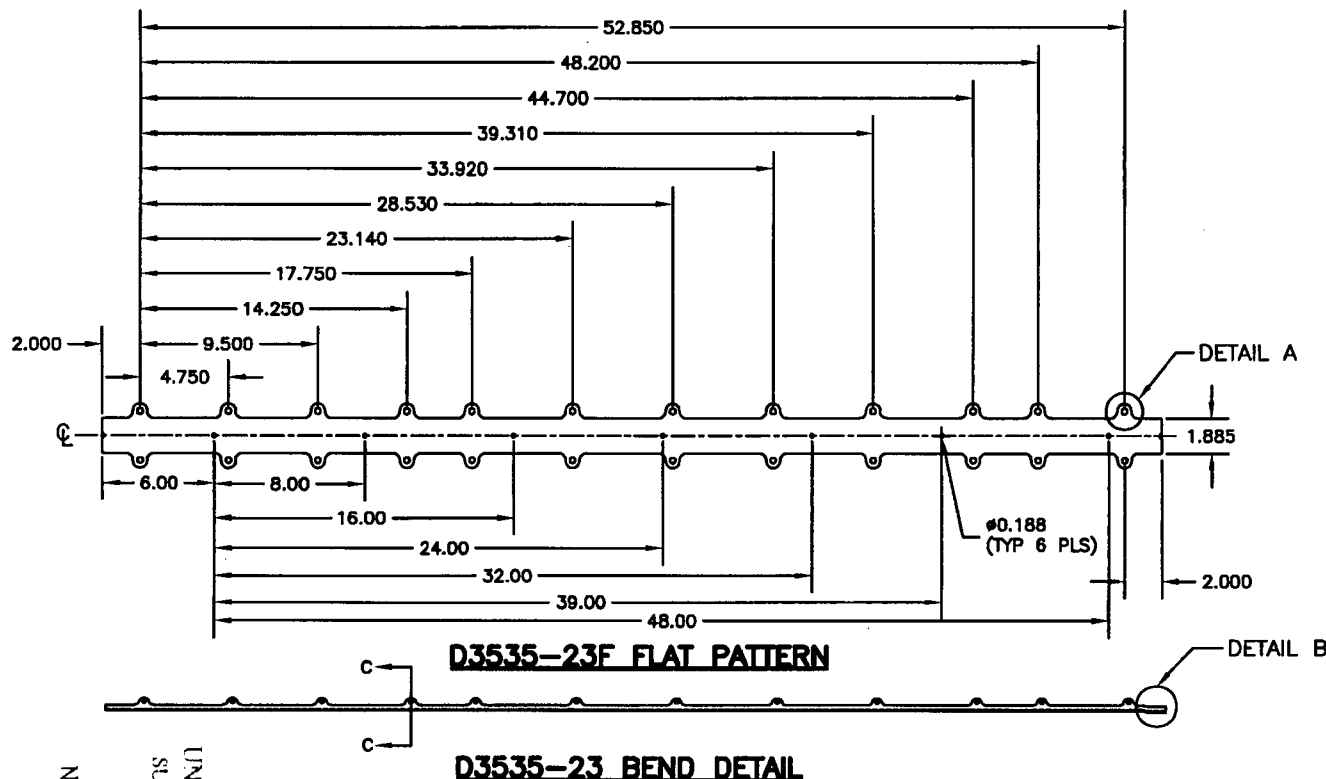
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL**

**DART**

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07.04.24



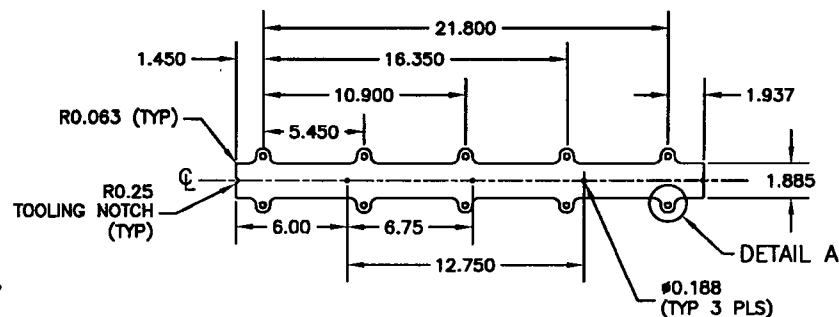
**D3535-23F FLAT PATTERN**

**D3535-23 BEND DETAIL**

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NO. 1504

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY. SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



**D3535-25F FLAT PATTERN**

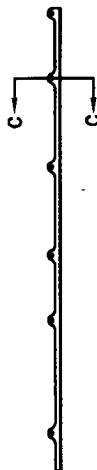
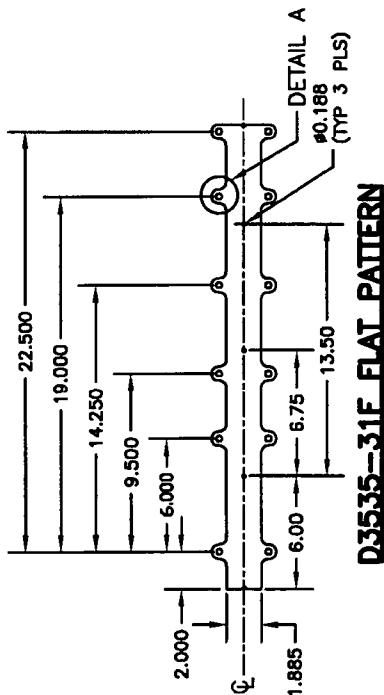
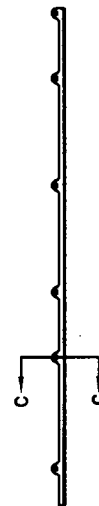
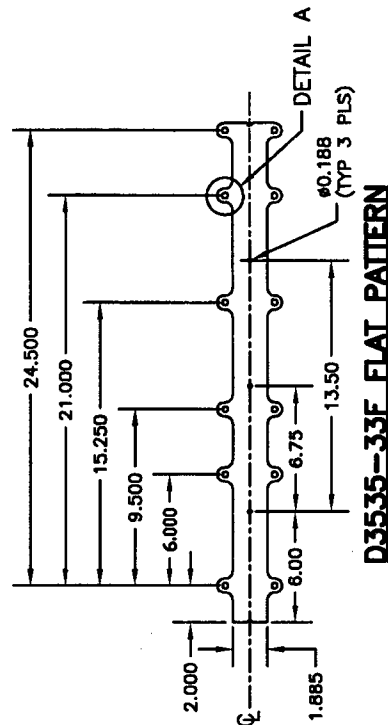
**D3535-25 BEND DETAIL**

| DESIGN   | DRAWN BY | DART AEROSPACE USA, INC. |
|----------|----------|--------------------------|
| CB       | PH       | PORT HADLOCK, WA         |
| CHECKED  | APPROVED | DRAWING NO.              |
| 11       | 11       | D3535                    |
| DATE     | TITLE    | SHEET 3 OF 7             |
| 07.04.17 | WEARSHOE | SCALE 1:10               |



**DART**

|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br><b>CB</b>           | DRAWN BY<br><b>PH</b>          | <b>DART AEROSPACE USA, INC.</b><br>PORT HADLOCK, WA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3535</b>                         | REV. B<br>SHEET 4 OF 7 |
| DATE<br><b>07.04.17</b>       | TITLE<br><b>WEARSHOE</b>       |   | SCALE<br>1:10          |

**RELEASED**07.04.24 *[Signature]***D3535-31 BEND DETAIL****D3535-33 BEND DETAIL**

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WORK ORDER  
NO. 441524

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDETEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

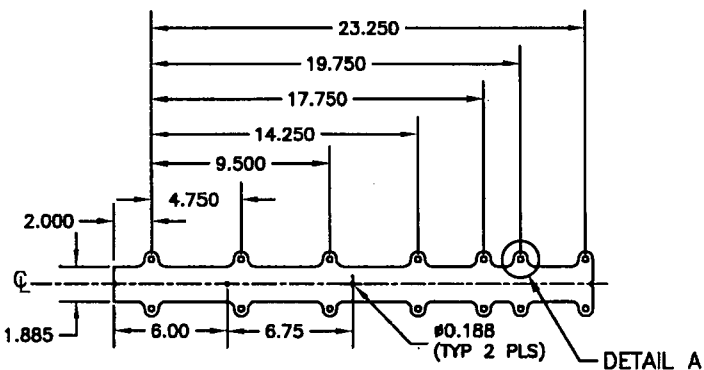
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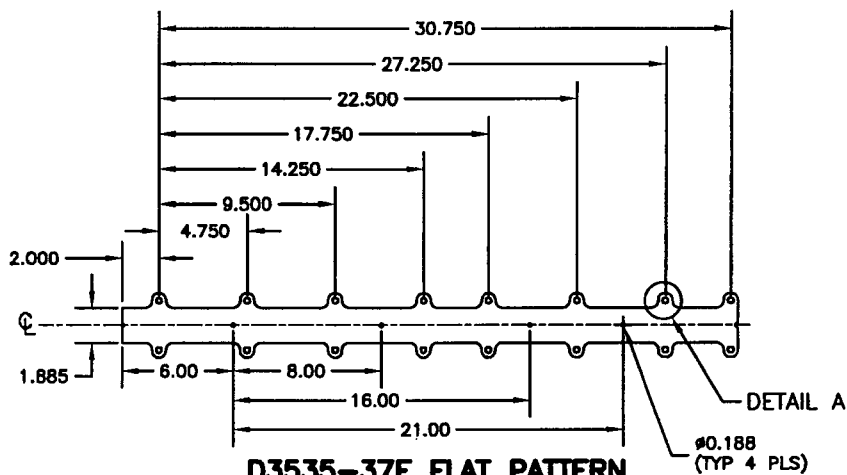
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**D3535-35F FLAT PATTERN**



**D3535-35 BEND DETAIL**



**D3535-37F FLAT PATTERN**



**D3535-37 BEND DETAIL**

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NO. 1507

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION

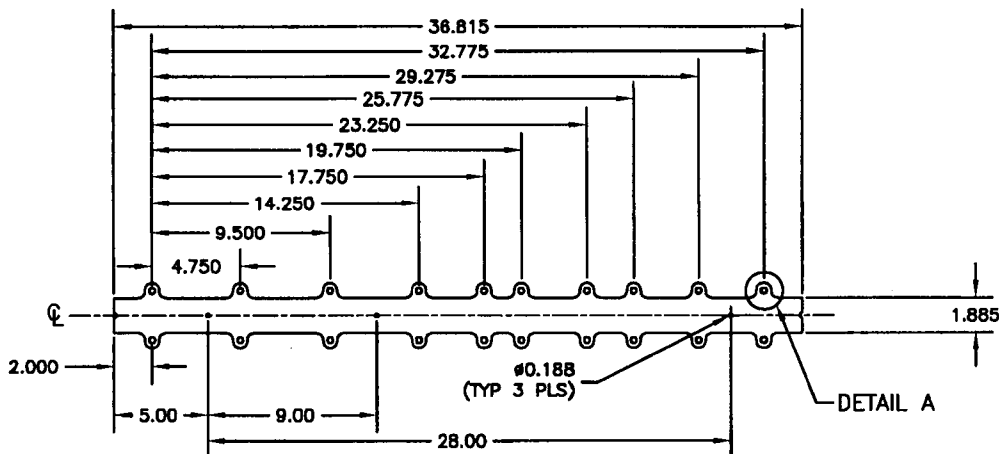
| DESIGN   | DRAWN BY | DART AEROSPACE USA, INC. |              |
|----------|----------|--------------------------|--------------|
| CB       | PH       | PORT HADLOCK, WA         |              |
| CHECKED  | APPROVED | DRAWING NO.              | REV. B       |
|          |          | D3535                    | SHEET 5 OF 7 |
| DATE     | TITLE    | SCALE                    |              |
| 07.04.17 | WEARSHOE | 1:10                     |              |

**DART**

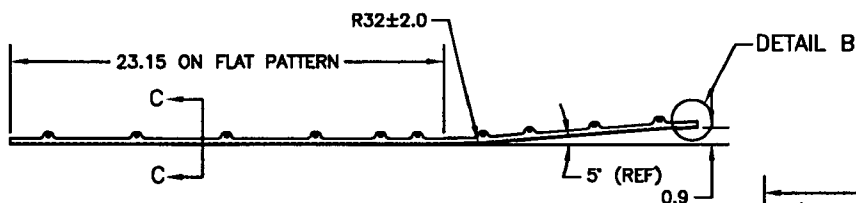
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07.04.17

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|----------|----------|--------------------------|--------------|
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| CHECKED  | APPROVED | DRAWING NO.              | REV. B       |
|          |          | D3535                    | SHEET 6 OF 7 |
| DATE     | TITLE    | WEARSHOE                 | SCALE        |
| 07.04.17 |          |                          | 1:10         |



**D3535-39F FLAT PATTERN**

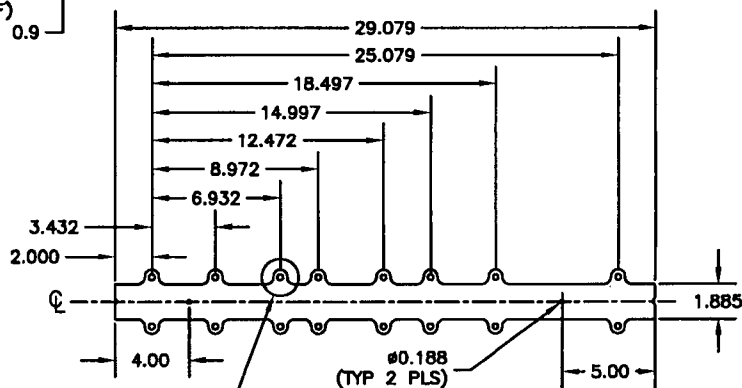


**D3535-39 BEND DETAIL**

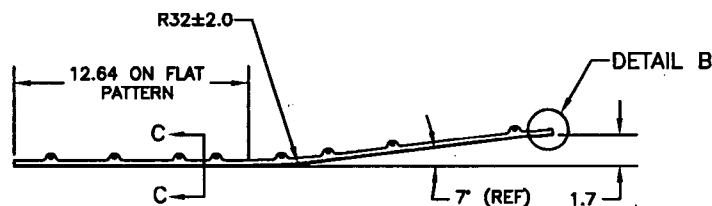
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WORK ORDER  
NO. 1552

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



**D3535-41F FLAT PATTERN**

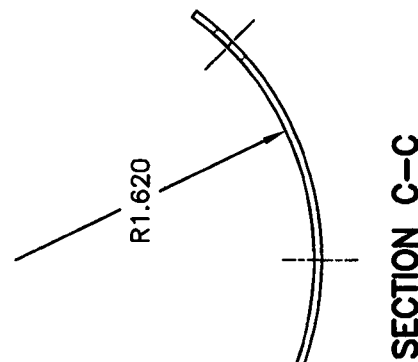
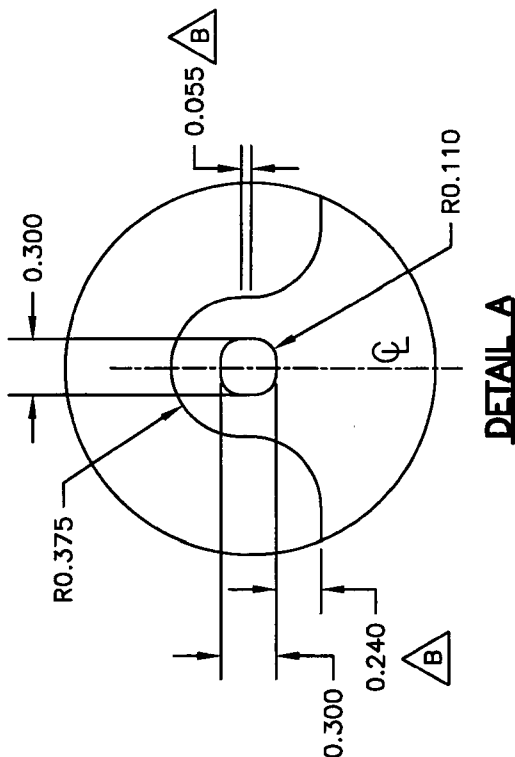
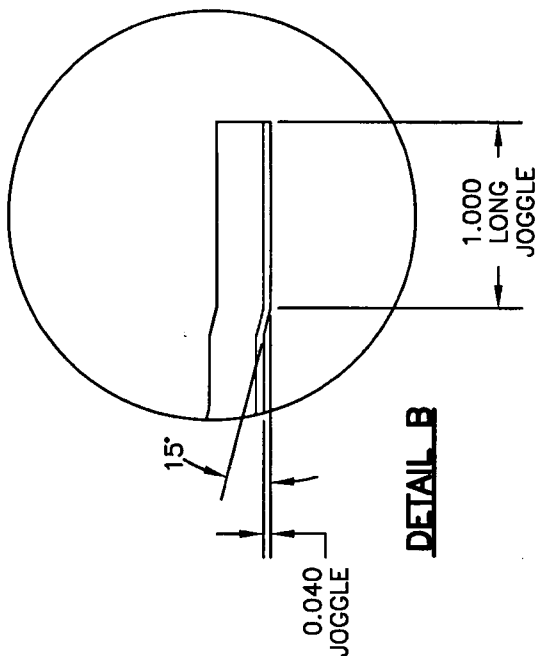


**D3535-41 BEND DETAIL**



|                               |                                |  |                        |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN<br><b>CB</b>           | DRAWN BY<br><b>PH</b>          | DART AEROSPACE USA, INC.<br>PORT HADLOCK, WA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3535                         | REV. B<br>SHEET 7 OF 7 |
| DATE<br>07.04.17              |                                | TITLE<br>WEARSHOE                            | SCALE<br>1:1           |

RELEASED  
07.04.24 *[Signature]*



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